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5015672

Ke print
D206-642-312BL
Job Sheet 166709-E



Part No: D206-642-312BL

Job Qty: 1 ea

Part Name: Skidtube RH, Low & High Gear with Standard Wearplates (Ael Blue)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/16/17

Job Tracking No:

Due Date: 11/27/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Customer: Air Evac Lifeteam (CAEVA02)

Air Medical Group Holdings, Concur Invoice Capture C/O (*AEL*), 10700 Prairie Lakes Drive Eden Prairie, MN, 55344 USA ph:(636) 695-5385

Note: DWG REV Q SHEETS 29-30 IPP Rev: J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec IPP Rev:L 08-09-29 as per DSI9421 DD verified by: EC IPP Rev:M 09-03-02 as per DSI9440 rev.a verified by:EC IPP Rev:N 09-03-03 as per DSI9421 rev.b verified by:EC IPP Rev:O as per REV.N DD 10.04.19 verified by:EC IPP Rev:P 14.04.25 ECN14-520 DD verf:JLM IPP REV:Q 15.10.09 ADDED BL DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/27/17	0.00	0.00	Start Up Stores/Pkg-1		
100	DC	1 pcs		11/27/17	0.00	0.00	DC		
110	Packaging	1 pcs		11/27/17	0.00	0.00	Packaging1		
120	QC	1 pcs		11/27/17	0.00	0.00	QC4		
130	Packaging	1 pcs		11/27/17	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea		11/27/17	0.00	0.00	QC21		

Part Op 100 - Photocopy bluefile and create labels per PPP D206-642-312 CHG008

Descriptions: 130 - Identify and pack for shipping as per PPP D206-642-312 Location: _____ PPP Rev: **NOV 3 0 2017**

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	AN3-41A 501508	8 ✓	33	0	0
	AN4-6A 5013677	12 ✓	449	0	0
	AN4C5A 5013676	1 ✓	31	0	0
	AN5-10A 5013675	4 ✓	155	0	0
	AN5-11A 5013674	8 ✓	440	0	0
	AN5-12A 5013673	4 ✓	496	0	0
	D206-642-341BL	1 ✓	19	0	0
	D206-648-013BL 50115481	1 ✓	2	0	0
	D2652 5013672	16 ✓	340	0	0
	D2712 5013671	10 ✓	93	0	0
	D2932-2BL 5014583	1 ✓	0	0	0
	D2933-2BL 5013578	1 ✓	2	0	0
	D2934 F16435Z	2 ✓	28	0	0
	D2935 5015 F164460	2 ✓	48	0	0
	D2938-2BL 5013531	1 ✓	0	0	0
	D2939-2BL 5013531	1 ✓	0	0	0
	D3407-043 5013668	1 ✓	29	0	0
	D3413-1BL 5014290	1 ✓	21	0	0
	D3456-1 5013667	1 ✓	69	0	0
	5015006				

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

DISPOSITION	Re: _____	Work Order: _____ Part No. _____ NCR No. _____	Date : _____	Description Work Order Deviation
	Use _____ Suspected Unappr: _____		Step #: _____	

☐ Engineering ☐ Quality ☐ Other	☐ Water Jet ☐ Eng. Coord. ☐ Supplier	☐ MRB (QS1042) Approval	☐ Completed By	☐ Lead hand / Supervisor	☐ QC / QA Coordinator	☐ Approval
Root Cause						
☐ Environment	☐ Design	☐ Doc/Data	☐ Equip/Tooling	☐ Handling/Pre	☐ Material	☐ Internal Transport
☐ Tribal Knowledge	☐ LOA	☐ Substation	☐ Past Expiry Date	☐ Misidentified	☐ OTHER :	
☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier	☐ Training	☐ Use for Testing	☐ Poor Information
☐ Rushing	☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due	☐ Marks/Chatter	
☐ Pressure/Forced	☐ Bending	☐ Centre Not Concentric	☐ Cracks	☐ Crimp/Kink/Ripple/Wave	☐ Cuffs	☐ Heat Treat
☐ Wave/Twist in Tube	☐ Ins	☐ Cu	☐ Cu	☐ Cu	☐ Ins	☐ Drill Holes
Start up Operation Mfg Date: 11/30/17 Job No: 166709-E D206-642-312BL Skidtube RH, Low & High Gear with Standard Wearplates (Ael Blue) PART NO: Revision: Operation: Change No:						
DART AEROSPACE S015672 Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com						
☐ Positioned Wrong	☐ Outside Dimensions	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Drawing
☐ Finish	☐ Misread	☐ Turning Sequence	☐ Misaligned/off center			
☐ Fit/Function	☐ Unlabeled					

505613

D3457-1	2 ✓	14	0	0
MS21042L3 5013666	8 ✓	1,029	0	0
MS21042L4	12	1,019	0	0
MS21043-4 5013665	1 ✓	813	0	0
NAS1149C0463R 5013664	1 ✓	119	0	0
NAS1149D0363J 5013663	8 ✓	247	0	0
NAS1149D0463J 5013662	8 ✓	527	0	0
NAS1149D0563J 5013662	8 ✓	1,238	0	0

Part Specifications

Specifications could not be found.

Plex 11/20/17 3:29 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

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IIN-D206-642

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4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-11	WEARSHOE (REPLACES D3535-11 + D3536-11)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-35	WEARSHOE (REPLACES D3535-35 + D3536-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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